










Date: Thursday, 1/5/2006 8:52:02 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : ASSEMBLE
Job Number : 25403	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : D3197041
This Issue : 1/5/2006 S.O. No. : N/A	Drawing Number : D3197-1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : N/A	Drawing Revision : N/A
Previous Run : 00015	Material : N/A
Written By : <u>See Above date &amp; user</u>	Due Date : 1/12/2006
Checked & Approved By : <u>Same as Above</u>	Qty: <del>8</del> Um: Each
Comment :	3
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	PACKAGING 1 PACKAGING RESOURCE #1
	 
Comment: PACKAGING RESOURCE #1 REMOVE FROM STOCK D3197-1 B <u>24391</u> FF 06-01-05 3	
2.0	D26905 Lanyard ass'y
	 
Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s) Pick: Qty Part Number Description Batch 4 D2690-5 Lanyard <u>B 25259</u> FF 06-01-05 3	
3.0	D32421 Tag
	 
Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s) Pick: Qty Part Number Description Batch 4 D3242-1 TAG <u>B 25105</u> FF 06-01-05 3	
4.0	AN960JD10 Washer
	 
Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s) Pick: Qty Part Number Description Batch 12 AN960JD10 Washer <u>M19413</u> FF 06-01-05 3	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *LD*   Date:   *08/04/12*    
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ASSEMBLE

Job Number: 25403

Part Number: D3197041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

DARS004

Pip Pin



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 DARS-004

Pip Pin M19453

FF 06-01-05

6.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 MS21042L3

Nut (or -3) M18180

FF 06-01-05

7.0

MS27039124

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 MS27039-1-24 Screw

M19391

FF 06-01-05

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3197-041 as per Dwg D3197

FF 06-01-05

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

3 parts  
1.5 k.t.s.

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 99

06/01/05 (3)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

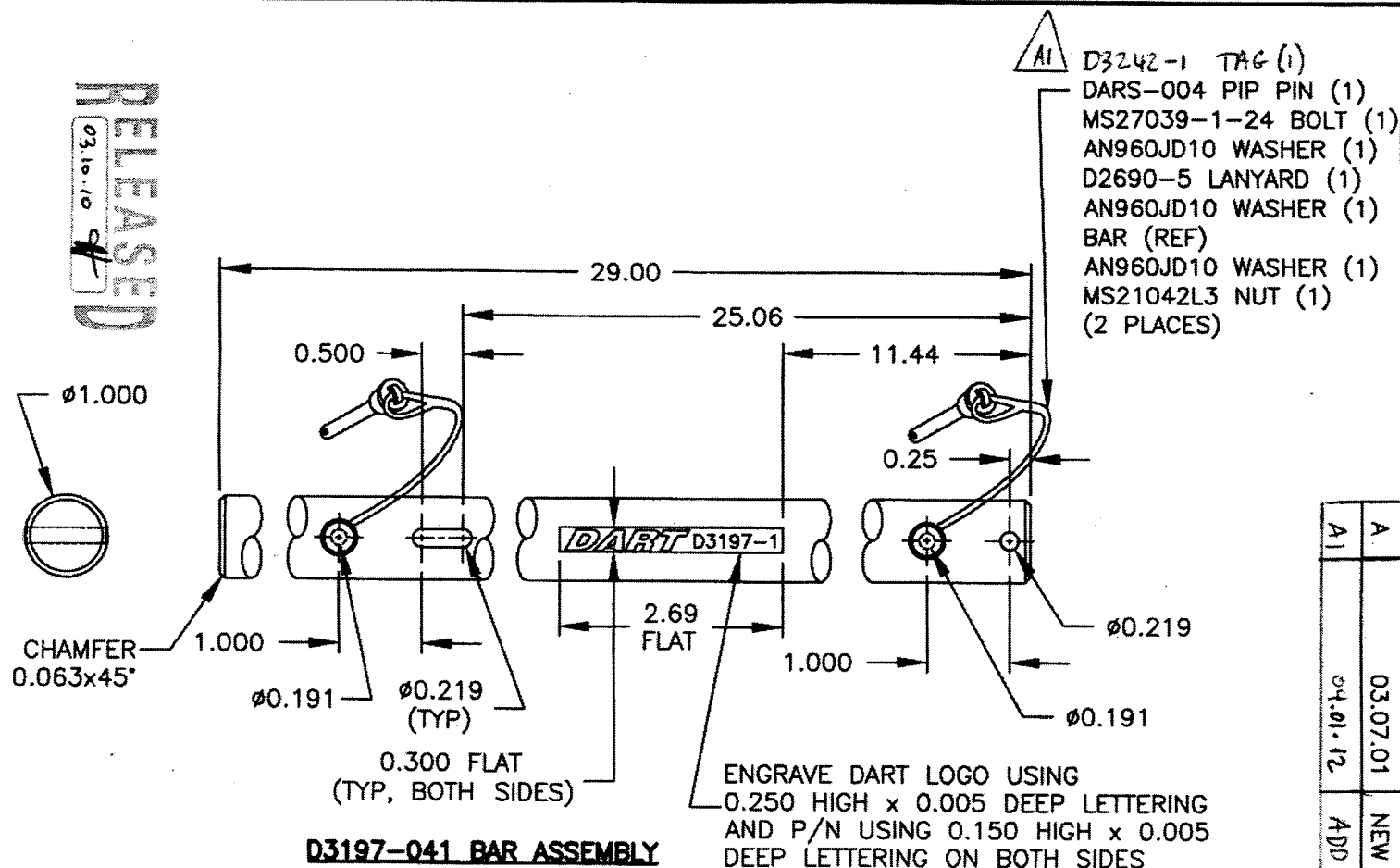
Inspection Level 21

545 06/01/16 (5)

06/01/12 (3)

QA COPY ISSUED

DESIGN	APPROVED BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3197	SHEET 1 OF 1
03.07.01		TITLE	SCALE
		BAR	1:1
A.	03.07.01	NEW ISSUE	
A1	04.01.12	ADD D3242-1 TAG	2



D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9)  $\phi$ 1.000 O.D.  
(REF DART SPEC. M7075T73R1.000)
- 2) POSSIBLE SUPPLIER FOR DARS-004 PIP PIN: REID TOOL SUPPLY.  
IT IS ACCEPTABLE TO REPLACE WITH ANY STAINLESS STEEL DOUBLE-ACTING QUICK-RELEASE PIN WITH A  $\phi$ 0.188 DIAMETER PIN, 1.8"-2.0" GRIP LENGTH, MIN. OF 200 lbs PULL-OUT STRENGTH, AND MIN. OF 5150 lbs DOUBLE SHEAR.
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

03.10.10 *[Signature]*

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